

# Work Order ID 67520 -1

Monday, March 28, 2011 7:24:58 AM

Page 1

Item ID: D3183-045

Revision ID:

Item Name: Bearing Assembly

Start Date: 3/28/2011 Start Qty: 50.00

Required Date: 3/30/2011 Req'd Qty: 50.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Draw Nbr

Revision Nbr

D3183

Rev C1

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

Memo

Turn D3183-9 Cap as per Folio FA388 Debur

0.00

0.00

11.3.28

50

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

11.3.28

50

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

11.3.28

50

Accept



Setup Start

Stop



Cust Item ID:

Customer:



Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: D3183-045

Accept

Revision ID:



Setup Start

Item Name: Bearing Assembly

Stop



Start Date: 3/28/2011 Start Qty: 50.00



Required Date: 3/30/2011 Req'd Qty: 50.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



Small Fab

Small Fab

0.00

Small Fab

Memo

0.00

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

*JS* 03/31 (38)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*S* 03/31

*count*  
(38)

150



Packaging

Packaging

Identify as per dwg & Stock Location: *236*

0.00

Memo

0.00

*11/4/11* (38) ✓

W/O:		WORK ORDER CHANGES						
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 67520

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Item ID: D3183-045

Accept

Revision ID:

Item Name: Bearing Assembly

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Required Date: 3/30/2011 Req'd Qty: 50.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/  
Run Hours

0.00

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11/04/04 AG

mf

11-03401



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

Monday, March 28, 2011 7:24:54 AM

7



**Required Qty: 50.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-5  Bearing	Manufactured	No				110	Each	23.0000	1	50		10/3/31	



No

ST236

67065

23

Loc Code

130

f

14,0000

0.0333

1.752632

### Location

MATO55

116266

Loc Qty

14

Loc Code

14

W/O:		WORK ORDER CHANGES							
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**NOTE:** Date & initial all entries





DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

w/o 67520

DETAIL A (2:1)

DEO ATTACHED

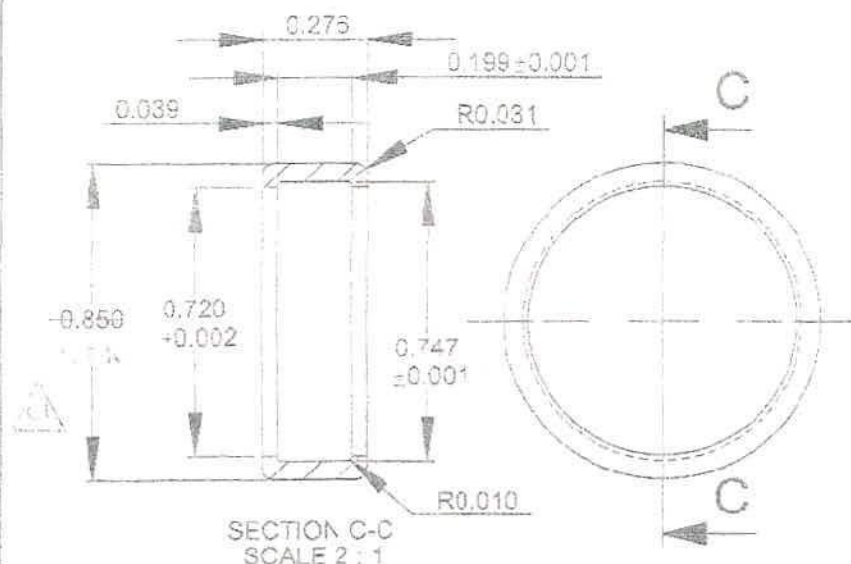
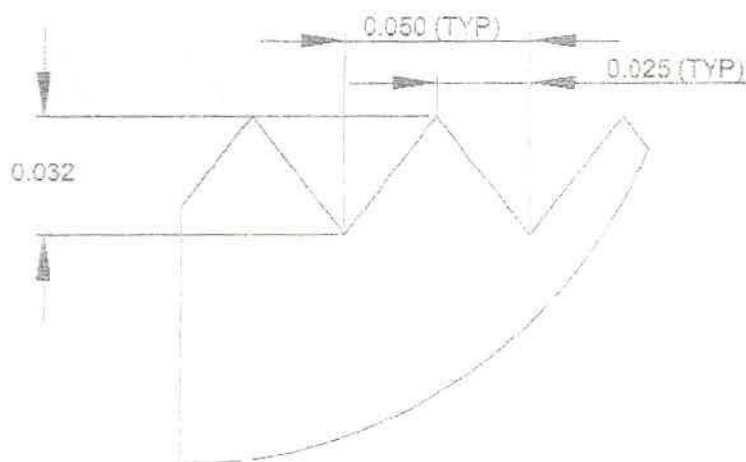
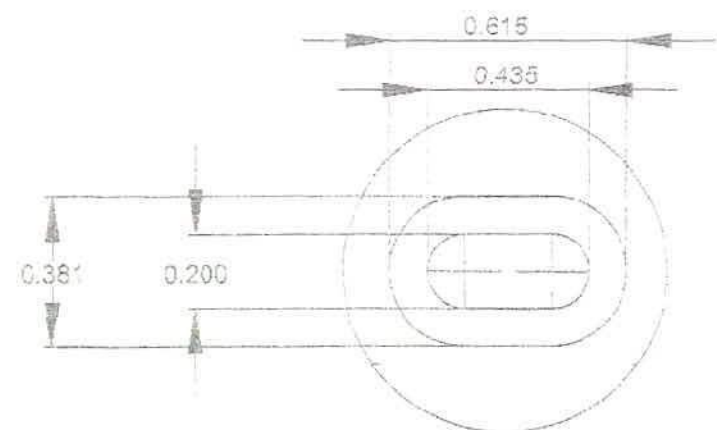
DETAIL B (20:1)

**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP



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